

C6458777

MODEL 700™ 1124

Model **SWS**™

Action

Barrel Length

Capacity

Order No. **5715**

* Includes 1 in chamber.



CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6498777

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	6 29	90	RW
600	Proof	6 29	90	RW
607	Check Headspace	6 29	90	RW
610	Dis-assemble Gun	6 29	90	RW
612	Magnaflux Barrel Action		7-12-90	KR
	Magnaflux Bolt		7-12-90	KR
615	Rollmark Caliber		7-12-90	G.L.
617	Drill and Tap Sight Holes		7/19/90	LB
618	Polish Barrel <i>LB</i>		7/16/90	WB
620	Apply Coatings (Barrel Action)		7-23-90	TJA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		7/25/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		7/25/90	RW
	C) Inspect Ejector Hole for Chamfer		7/25/90	RW
	D) Oil Firing Pin Ass'y		7/25/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		8/17/90	GL

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	5	4			8/9/90	RL
	G) Safety Off Force	3	3	3			8/9/90	RL
	H) Trigger Pull Test & Retainability						8/17/90	RL
	I) Firing Pin Indent	.0225	.0225	.0225			8/19/90	RL
	J) Assemble Stock						8/20/90	RW
	K) Assemble Swivel Studs						8/24/90	QJ
	L) Attach Front and Rear Sight Assemblies						8/20/90	RW
	M) Iron Sight Alignment						8/20/90	RW
	N) Detach Front & Rear Sights & place in numbered container						8/20/90	RW
	O) Attach Scope to Rifle						8/20/90	RW
	P) Detach & Attach Scope 20 Times						8/20/90	RW
640	Gallery Target & Test						8-20-90	AF
	A) Time						8-20-90	AF
	B) Malfunctions						8-20-90	AF
	C) Pierced Primers						8-20-90	AF
	D) Optical Clarity of Scope						8-20-90	AF
645	Inspect for Live Ammo						8-20-90	AF
655	Final Inspection							
	A) Headspace						8/29/90	QJ
	B) Trigger Pull	2.15	2.13	2.14	2.15	2.18	8/29/90	QJ
	C) Function						8/29/90	QJ
660	Pack						9/20/90	AF

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS
2.50# + .50#
3.00# + .75#
4.00# + 1.00#

SERIAL NO. CL498777
DATE 8/17/90
TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.42	2.35	2.30	2.15	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.49	2.36	2.43	2.13	
PULL #3	2.35	2.45	2.35	2.14	
PULL #4	2.37	2.41	2.40	2.15	
PULL #5	2.35	2.40	2.42	2.18	
TOTAL	11.98	11.97	11.90	10.75	
AVG.	2.396	2.394	2.38	2.15	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.21	3.47		
PULL #2	3.21	3.44		
PULL #3	3.14	3.40		
PULL #4	3.20	3.46		
PULL #5	3.30	3.46		
TOTAL	16.06	17.23		
AVG.	3.212	3.446		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.31	4.30		4.16
PULL #2	4.29	4.34		4.40
PULL #3	4.26	4.29		4.15
PULL #4	4.34	4.35		4.20
PULL #5	4.29	4.37		4.40
TOTAL	21.49	21.65		21.31
AVG.	4.298	4.33		4.262

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6498777
21 Aug 1990

CENTROIDAL DISTANCES

0 TO	1	.253503
1 TO	2	.308172
1 TO	3	.167084
1 TO	4	.478323
1 TO	5	.150659

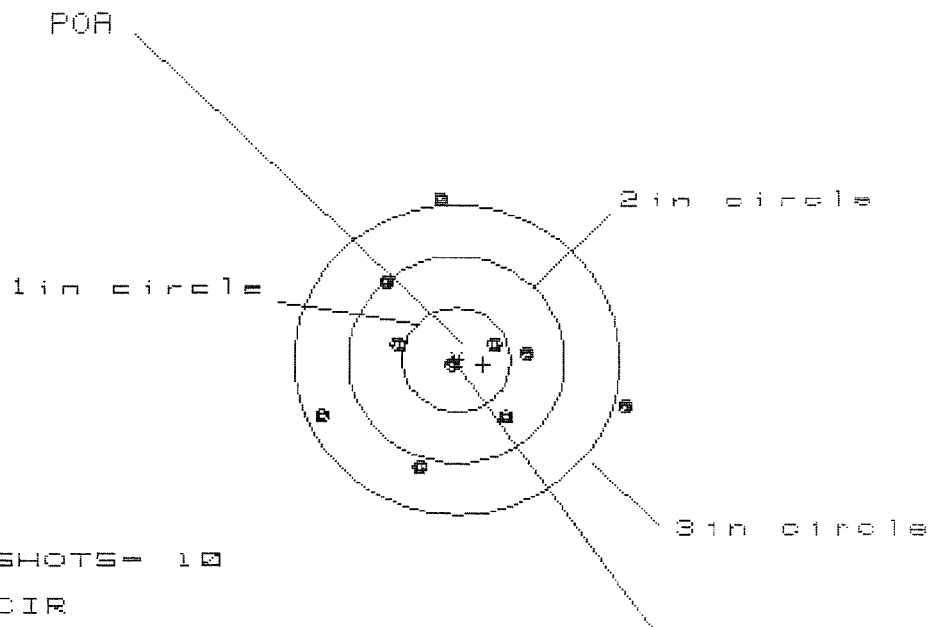
52
34 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.1202
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .011
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .120702
THE AMR FOR THIS RIFLE IS: .878

20 Aug 1990

FILE:/PATTERNING/CENTERFIRE_PATT/CS49B777

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 6

3 in = 8

HS= 2.831

VS= 2.627

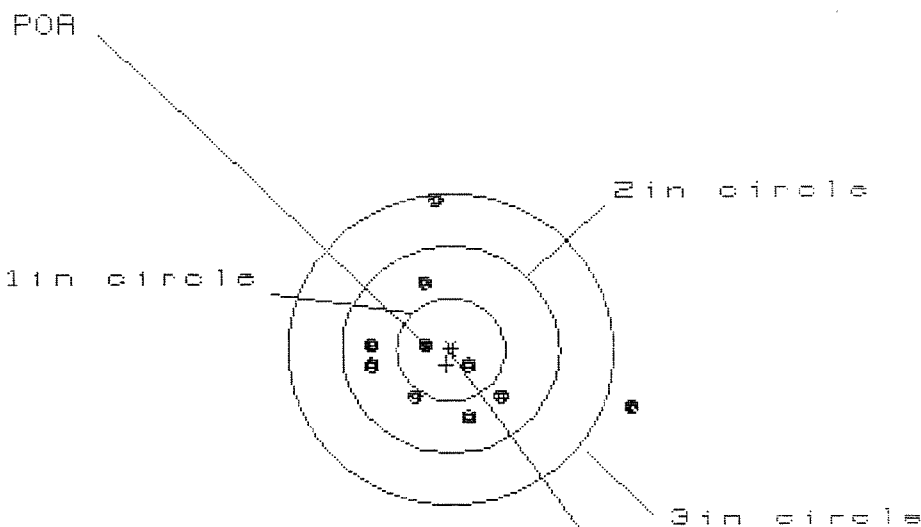
GS= 2.833

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.576	.823	.827
MINIMUM X	:	-1.255	-1.080	-1.076
MAXIMUM Y	:	1.544	1.497	.890
MINIMUM Y	:	-1.083	-1.130	-.943
CENTROID X	:	-.250	-.425	-.428
CENTROID Y	:	.042	.089	-.098
POA TO CENTROID in.	:	.254	.435	.440
MIN RADIUS	:	.077	.127	.155
MEAN RADIUS	:	.907	.829	.743
MAX RADIUS	:	1.632	1.497	1.149
HORIZONTAL SPREAD	:	2.831	1.903	1.903
VERTICAL SPREAD	:	2.627	2.627	1.833
EXTREME SPREAD	:	2.833	2.635	1.988
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	

20 Aug 1998

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 2

2in = 8

3in = 8

HS= 2.399

VS= 2.099

GS= 2.679

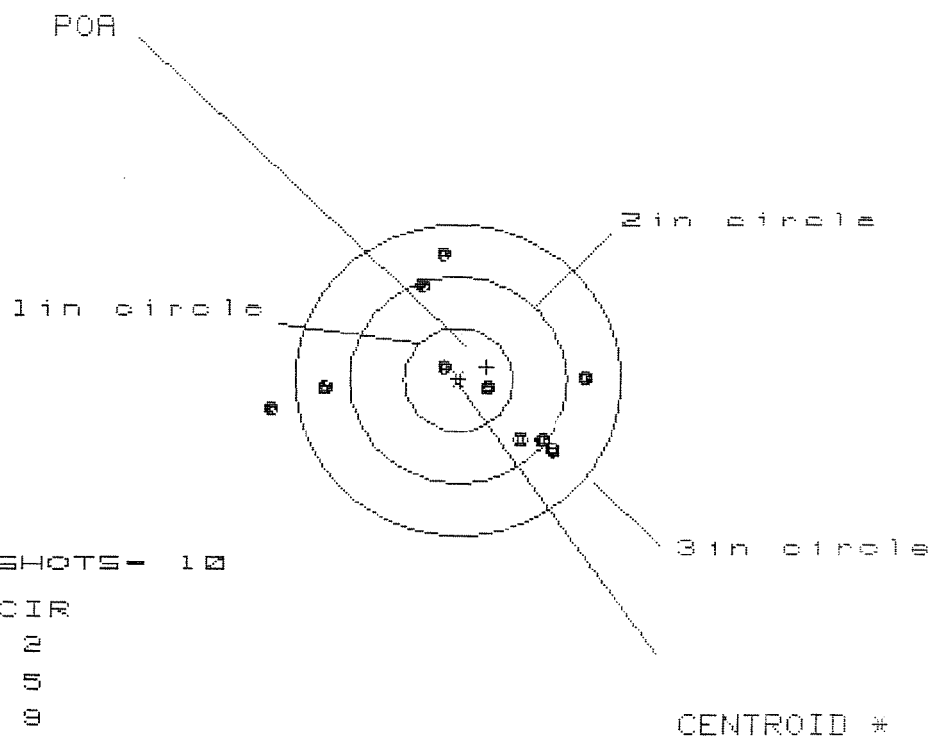
CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.669	.615	.624
MINIMUM X	:	-.729	-.544	-.535
MAXIMUM Y	:	1.496	1.440	.742
MINIMUM Y	:	-.603	-.659	-.479
CENTROID X	:	.039	-.147	-.156
CENTROID Y	:	.149	.205	.025
POA TO CENTROID in.	:	.154	.252	.158
MIN RADIUS	:	.230	.082	.199
MEAN RADIUS	:	.760	.622	.496
MAX RADIUS	:	1.743	1.442	.747
HORIZONTAL SPREAD	:	2.399	1.159	1.159
VERTICAL SPREAD	:	2.099	2.099	1.221
EXTREME SPREAD	:	2.679	2.112	1.285
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		8	

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 5

3 in = 9

HS= 2.897

VS= 1.838

GS= 2.913

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.180	.989	.811
MINIMUM X	:	-1.717	-1.429	-.659
MAXIMUM Y	:	1.205	1.174	1.157
MINIMUM Y	:	-.633	-.664	-.681
CENTROID X	:	-.269	-.078	.100
CENTROID Y	:	-.124	-.093	-.076
POA TO CENTROID in.	:	.296	.122	.126
MIN RADIUS	:	.200	.094	.156
MEAN RADIUS	:	.966	.851	.771
MAX RADIUS	:	1.740	1.435	1.276
HORIZONTAL SPREAD	:	2.897	2.418	1.470
VERTICAL SPREAD	:	1.838	1.838	1.838
EXTREME SPREAD	:	2.913	2.422	2.131
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS

4

POA

1 in circle

2 in circle

3 in circle

OF SHOTS- 10

IN CIR

1 in = 1

2 in = 7

3 in = 9

HS= 2.542

VS= 1.356

GS= 2.766

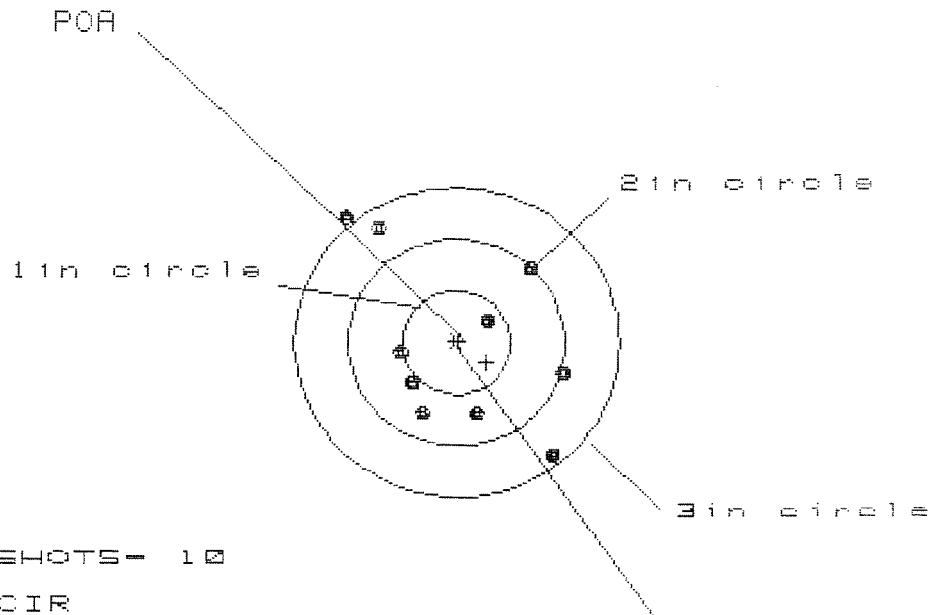
CENTROID *

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.369	1.061	.933
MINIMUM X	:	-1.172	-1.020	-.721
MAXIMUM Y	:	.683	.609	.652
MINIMUM Y	:	-.672	-.727	-.684
CENTROID X	:	.162	.009	.137
CENTROID Y	:	-.201	-.126	-.169
POA TO CENTROID in.	:	.257	.126	.217
MIN RADIUS	:	.462	.375	.454
MEAN RADIUS	:	.840	.733	.699
MAX RADIUS	:	1.526	1.172	1.039
HORIZONTAL SPREAD	:	2.542	2.081	1.654
VERTICAL SPREAD	:	1.356	1.336	1.336
EXTREME SPREAD	:	2.766	2.245	1.849
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 1

2in = 6

3in = 9

HS= 1.971

VS= 2.358

GS= 3.023

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.959	.846	.942
MINIMUM X	:	-1.012	-.811	-.715
MAXIMUM Y	:	1.227	1.215	1.091
MINIMUM Y	:	-1.131	-.995	-.635
CENTROID X	:	-.283	-.170	-.266
CENTROID Y	:	.189	.053	.177
POA TO CENTROID in.	:	.340	.178	.320
MIN RADIUS	:	.373	.386	.365
MEAN RADIUS	:	.917	.823	.767
MAX RADIUS	:	1.590	1.461	1.304
HORIZONTAL SPREAD	:	1.971	1.657	1.657
VERTICAL SPREAD	:	2.358	2.210	1.726
EXTREME SPREAD	:	3.023	2.716	2.148
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	6		
NUMBER IN THREE INCH CIRCLE	=	9		

Remington® **DUPONT** REG. U.S. PAT. & TM. OFF.

MODEL 700™ H24

MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.

SERIAL NO. C6498777

ORDER NO. 5716

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